

Work Order ID 149071

Tuesday, July 19, 2016 2:42:52 PM

149071

Page 1

Item ID: D4634-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Middle, Center Ceiling Panel Assembly
Start Date: 7/5/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: **JUL 20 2016** Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	G								

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

AUG 29 2016

DAS
6
9-89

110

0.00

110

Small Fab

Memo

0.13

Small Fab

***BEFORE INTALLING D4728-051, APPLY A 3/16" SEEM OF PLASTIC-
WELD 2 ON TOTAL LENGHT OF PART ON EANCH SIDE OF LIGHT, LET
DRY FOR ONE HOUR***
PLASTIC-WELD 2 BATCH : m135436

DAS
27
9-89

NOV 03 2016

1- Assemble as per Dwg D4634-043

2- Install led lights

3- Install Air valves

4-Install wiring harness

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Page 2

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** ***NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.00				①	16-11-16		
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							DAS 27 9-89
130									
Packaging	Memo	0.00							
Packaging									
									NOV 22 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.02							
Quality Control									16/11/22 JF

DAS
21
9-89

NOV 22 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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				Completed By					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, July 19, 2016 2:42:57 PM

Page 1

Work Order ID: 149071

149071

Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 7/5/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM IPP Rev C 13/07/09
Dwg Update DL verf: DD IPP Rev D Dwg Update 13/12/23
DL IPP REV E Dwg update 14/01/09
DL IPP Rev F Dwg. update 14/02/03
DL IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4652-5 *D4652-5* Air Valve, 1.25 Id Disk Type		Manufactured	No			100	Each	0.0000	2	2 122691			DAS 6 9-89
D4634-143 *D4634-143* Middle, Center Ceiling Replacement Panel Assembly		Manufactured	No			100	Each	0.0000	1	1 B49112		AUG 29 2016	SmB
D4646-1 *D4646-1* Plenum Cap Assembly		Manufactured	No			100	Each	63.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF009				63					
				124234				13					
				125003				50					
D4728-053 *D4728-053* Cabin Lights #2		Manufactured	No			100	Each	20.0000	1	1 2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF003				2					
				117933				2					
				over001				18					
				122551				18					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

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Page 2

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Parent Item: D4634-043

D4634-043

Parent Item Name: Middle, Center Ceiling Panel Assembly

Start Date: 7/5/2016

Required Date: 7/19/2016

Start Qty: 1.00

Required Qty: 1.00

PLT1.5M-M

Purchased

No

100

Each

2,855.000

3

3

PI T1 5M-M

Tie Wrap

Location

Loc Qty

Loc Code

ST585

2855

m129712

2855

100

Each

62.0000

2

2

2351-20-27-C3C

2351-20-27-
Z3CT

Purchased

No

DAS
6
9-89

2351-20-27-C3C

STUD

Location

Loc Qty

Loc Code

ST569

62

m128068

19

m130518

43

100

Each

97.0000

2

2

50-009-2

Purchased

No

50-009-2

Grommet

Location

Loc Qty

Loc Code

ST562

97

m128047

47

m131501

50

DAS
6
9-89

AUG 29 2016

Tuesday, July 19, 2016 2:42:57 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



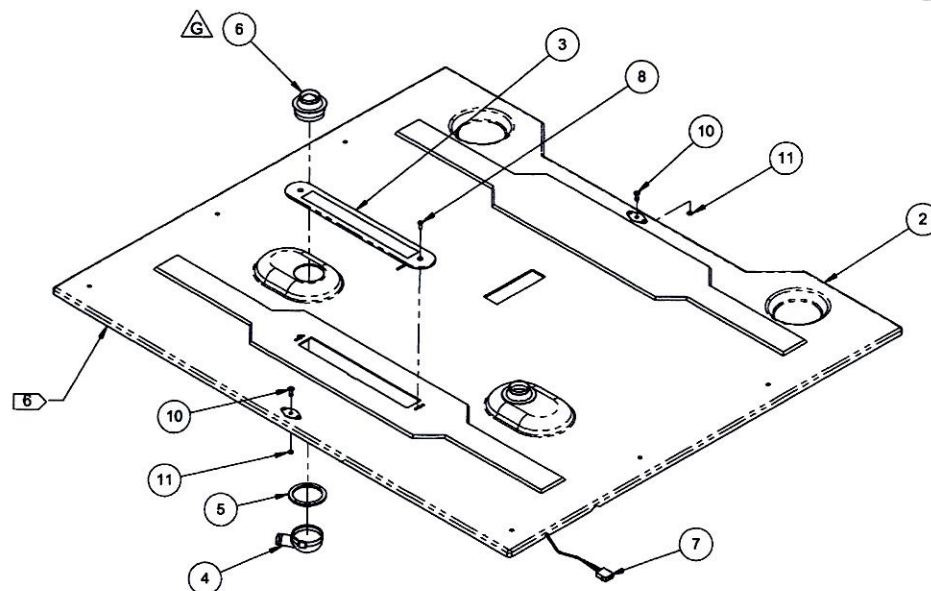
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

ITEM NO.	QTY. -043	P/N	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-143	MIDDLE, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4638-1 (REF)	LED LIGHT (REF PART OF D4728-053)
4	2	D4646-1	PLENUM CAP ASSEMBLY
5	2	D4652-3 (REF)	MOUNTING NUT (PART OF D4652-5)
6	2	D4652-5	AIR VALVE, 1.16 ID DISK TYPE
7	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
8	2	N/A (REF)	SCREW (PART OF D4638-1)
9	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)
10	2	2351-20-27-C3C	DZUS STUD, OVAL HEAD
11	2	50-009-2	GROMMET



D4634-043 MIDDLE, CENTER CEILING PANEL ASSY

NOTES:

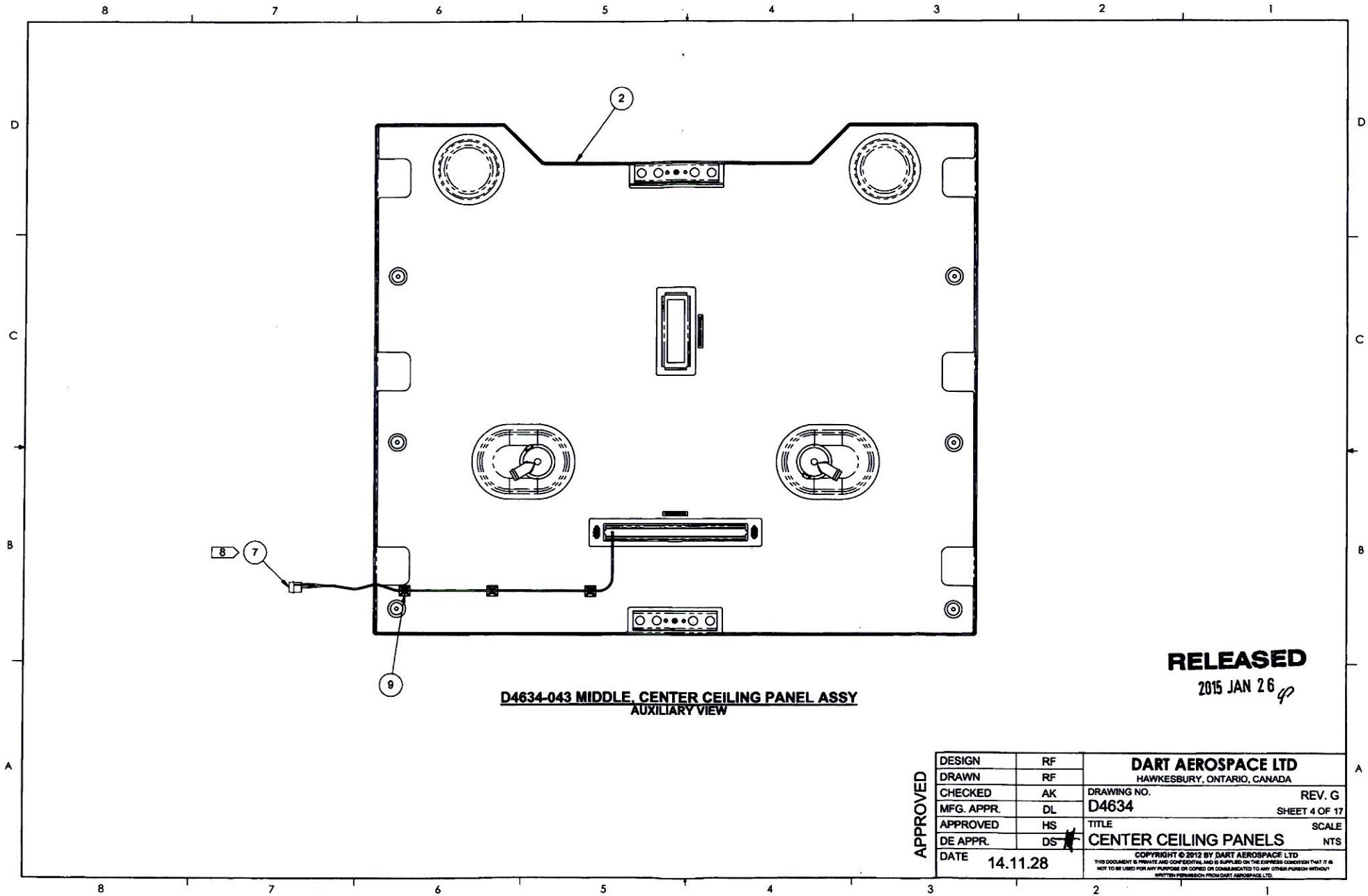
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) INSTALL D4728-053 WIRE HARNESS PER QSI 048

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 149071 M15
1607-20

RELEASED

2015 JAN 26

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO.	REV. G
	MFG. APPR.	DL	D4634	SHEET 3 OF 17
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CENTER CEILING PANELS	NTS
DATE		14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RELEASED
2015 JAN 26 *q*

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	AK	DRAWING NO. D4634	REV. G SHEET 4 OF 17
	MFG. APPR.	DL	TITLE	SCALE
	APPROVED	HS	CENTER CEILING PANELS NTS	
	DE APPR.	DS		
	DATE	14.11.28	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBOD OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Linda Lacelle

From: Linda Lacelle
Sent: Monday, May 11, 2015 12:59 PM
To: Nigel Forbes
Subject: FW: 139 Ceilings Deviation

All Mike G...

From: David Shepherd
Sent: May-11-15 12:58 PM
To: Nigel Forbes; Bill Beckett
Cc: Roberto Fuentes; Linda Lacelle; Mario Poulin; Daryl Leger; Harvey Siemens
Subject: RE: 139 Ceilings Deviation

Nigel/Bill,

Can you clarify what is going on here. About 6 months ago, Operations pushed Engineering to change the lights and air vents previous lights and air vents were waaaaaaay too expensive. Now we have 3 years supply of the old expensive parts. I'm con

Regards,
David

From: Mario Poulin
Sent: May-11-15 10:53 AM
To: Daryl Leger; Harvey Siemens
Cc: Roberto Fuentes; David Shepherd; Linda Lacelle
Subject: RE: 139 Ceilings Deviation

No orders pending,

From: Daryl Leger
Sent: Monday, May 11, 2015 12:49 PM
To: Mario Poulin; Harvey Siemens
Cc: Roberto Fuentes; David Shepherd; Linda Lacelle
Subject: RE: 139 Ceilings Deviation

Harvey
Re: 139 Ceilings

We have	old stock quantities of	D4652-1 air Valve	QTY 163. (enough old stock for 13 sets)	New Stock Qty. 0
	Old stock quantity of	D4638-1 light	QTY 73. (enough old stock for 24 sets)	New Stock Qty. 0

We do not have any orders on hand for ceilings and I have no idea if there are any pending orders.
Please advise

Daryl

From: Mario Poulin
Sent: Monday, May 11, 2015 10:45 AM
To: Harvey Siemens; Daryl Leger

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Cc: Roberto Fuentes; David Shepherd; Linda Lacelle

Subject: RE: 139 Ceilings Deviation

Harvey,

We have stock for about 3 years, Ok to keep some old ones in case, but we should be reducing inventory first.

Mario,

From: Harvey Siemens

Sent: Monday, May 11, 2015 10:18 AM

To: Daryl Leger

Cc: Roberto Fuentes; Mario Poulin; David Shepherd

Subject: RE: 139 Ceilings Deviation

Daryl,

I thought we were going to move to the new parts and not use up all the old stock in case somebody wanted/needed replace

Just a little curious, why we are going backwards??

HS

From: Daryl Leger

Sent: May-11-15 5:56 AM

To: Harvey Siemens

Cc: Roberto Fuentes; Mario Poulin

Subject: 139 Ceilings Deviation

Harvey

Can you please provide a standard email that we can use to make D4634-xxx panels at Rev. F until old stock parts are used up

We will also need same type document to produce D4635-xxx panels as per Rev. E until old stock parts are used up.

We will not use unmatched parts (old/new on same set panel) as old stock diminishes.

Daryl

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					